

# Work Order ID 64869

Monday, December 20, 2010 2:51:22 PM



Page 1

Item ID: D4086-210

Accept



Setup Start



Revision ID:

Stop



Item Name: Placard, Max Load

Start Date: 12/20/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/27/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date:

*12/20/20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4086

A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *13177*

Fabricate as per Dwg D4086

Possible Supplier: Studio Lettrage

Material release note is required

*PL 12/20/20*  
*(10)*

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

*PL 12/21/21*  
*(10)*

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

*8/20/21*

*(X10)*

**Work Order ID 64869**

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Page 2

Item ID: D4086-210

Accept

Revision ID:

Item Name: Placard, Max Load

Start Date: 12/20/2010 Start Qty: 10.00

Required Date: 12/27/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 127

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/22/22 (10)12/22/2212/22/22 (10)

# Picklist Print

Monday, December 20, 2010 2:51:25 PM

Page 1

Work Order ID: 64869

Parent Item: D4086-210

Parent Item Name: Placard, Max Load




Start Date: 12/20/2010

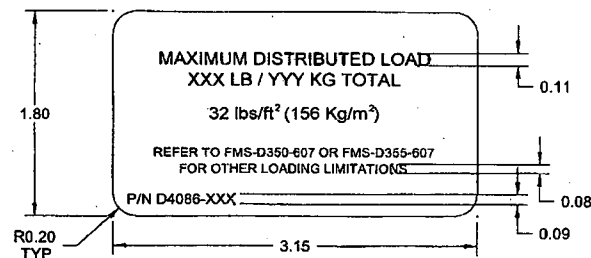
Required Date: 12/27/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A new issue DD 10.03.16 verified by:EC

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D4086-210P<br><br>Placard, Max Load |                        | Purchased     | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 10           |               | 12/21/10       | EC     |



8 **D4086-XXX PLACARD, MAX LOAD**  
(XXX = ALLOWABLE WEIGHT)

| PART NUMBER | LOAD            |
|-------------|-----------------|
| D4086-200   | 200 lb / 91 kg  |
| D4086-210   | 210 lb / 95 kg  |
| D4086-215   | 215 lb / 98 kg  |
| D4086-220   | 220 lb / 100 kg |
| D4086-232   | 232 lb / 105 kg |
| D4086-243   | 243 lb / 110 kg |

**NOTES:**

- 1) MATERIAL: RED LETTERS WITH WHITE BACKGROUND AND ADHESIVE BACK.  
MANUFACTURED FROM 3M, 7 MIL MASKING FILM #8522CP OR  
AVERY IPM #2031
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) PART NUMBER = D4086-MAX DISTRIBUTED WEIGHT IN POUNDS (lbs) OF THE BASKET.  
EXAMPLE: D4086-210 IS A BASKET WITH MAX DISTRIBUTED WEIGHT OF 210 POUNDS (lbs).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

10.08.04  
D1-10-12-20

**RELEASED**  
10.08.17 CP  
ECN 10-926

|            |  |     |          |
|------------|--|-----|----------|
| B          | ADDED -2001-215 PLACARDS.<br>REASON: ADDITION OF D350-607-54X BASKET SERIES. | MB  | 10.08.04 |
| A          | NEW ISSUE  | JPH | 10.03.08 |
| REV.       | DESCRIPTION  | BY  | DATE     |
| DESIGN     |  |     |          |
| DRAWN      |  |     |          |
| CHECKED    |  |     |          |
| MFG. APPR. |  |     |          |
| APPROVED   |  |     |          |
| DE APPR.   |  |     |          |
| DATE       | 10.08.04   |     |          |

|  |                        |
|--|------------------------|
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |                        |
| DRAWING NO.<br><b>D4086</b>  | REV. B<br>SHEET 1 OF 1 |
| TITLE<br><b>PLACARD, MAX LOAD</b>  | SCALE<br>NTS           |
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO13171**

Purchase Order Date 12/20/2010

PO Print Date 12/20/2010

Page Number 1 of 1

**Order From :**

VC-STU001

STUDIO DE LETTRAGE 2001  
210 MAIN WEST  
HAWKESBURY, ON K6A 2H6  
CA

**Contact Name**

**Vendor Phone**

613 632 5449

**Vendor Fax**

613 632 9491

**Vendor Account Nbr**

**Buyer**

Brigitte Golden

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

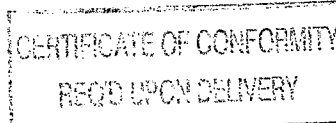
Destination-Collect

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

| Line Nbr  | Reference<br>Revision ID<br>Vendor Part Number | Description/<br>Mfg ID | Req Date/<br>Taxable | Req Qty/<br>Unit of Measure | Ship Method | Unit Price                | Extended<br>Price |
|-----------|--|------------------------|----------------------|-----------------------------|-------------|---------------------------|-------------------|
| 1         | D4086-210P                                     | Placard, Max Load      | 12/27/2010<br>Yes    | 10.00<br>Each               | Yours ppd   | \$5.0000<br><i>\$7.50</i> | \$50.00           |
| PO Total: |  |                        |                      |                             |             |                           | \$50.00           |



Change Nbr: 1

Change Date: 12/20/2010

No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required when applicable

**210 Main Street W**  
**Hawkesbury, Ontario K6A 2H6**

|               |            |
|---------------|------------|
| Invoice No.:  | 15033      |
| Date:         | 12/21/2010 |
| Ship Date:    |            |
| Page:         | 1          |
| Re: Order No. | 10069      |

**Dart Aerospace Ltd**  
1270 Aberdeen  
Hawkesbury, Ontario  
K6A 1K7

Dart Aerospace Ltd  
Hawkesbury, Ontario

| Item No.                                | Unit | Quantity | Description            | Tax | Unit Price          | Amount |
|---|------|----------|------------------------|-----|---------------------|--------|
|   |      | 10       | D4086-210P             | H   | 5.00                | 50.00  |
|   |      | 1        | printing               | H   | 25.00               | 25.00  |
|   |      |          | H - HST 13%            |     |                     |        |
|   |      |          | HST                    |     |                     | 9.75   |
|   |      |          | PST Exempt: #6122-5207 |     |                     |        |
|   |      |          | <i>Σ 10/21</i>         |     |                     |        |
| Studio de Lettrage HST: #869034678RP001 |      |          |                        |     |                     |        |
| Shipped By: Tracking Number:            |      |          |                        |     |                     |        |
| Comment: PO 13171                       |      |          |                        |     |                     |        |
| Sold By:                                |      |          |                        |     |                     |        |
|   |      |          |                        |     | <b>Total Amount</b> | 84.75  |



# Scotchcal™

## Opaque Imaging Media 8522

### Product Bulletin 8522

Release F, Effective January 2003  
Black bar in margin indicates a change

### Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

### Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
  - For opaque (reflective) graphics
  - Changeable, easy to remove from warranted substrates up to 1 year later
  - Dries quickly after printing so the overlamine can be applied almost immediately
  - Low slippage paper liner for superior tiling
- Overlaminates:
  - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
  - Available in luster and matte gloss
  - Adhesive allows for heat-assisted or cold-temperature lamination

### Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
  - Graphics for vans, personal vehicles, trucks and buses
  - Novelty posters
  - Retail and point-of-purchase displays
  - Information graphics such as maps and directories
  - Entertainment promotions in museums, zoos, parks, theatres, sports venues
  - Education and presentation graphics

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications

### Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

## Compatible Products and Equipment

### Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
  - Epson Archival Inks
- Epson Stylus Pro 10600 printer
  - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
  - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
  - HP83UV Color Ink System

### Overlaminates (required)

- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

### Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

### Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

### Characteristics

| Characteristic                 | Description  |
|--------------------------------|--|
| Media                          | 7 mil, white, opaque graphic film  |
| Liner                          | Low-slippage, lay flat paper   |
| Adhesive                       | Changeable, pressure sensitive   |
| Thickness (media and adhesive) | 7.5 to 8 mil (nominal)   |
| Application substrates         | See Warranted Substrates, above  |
| Application surfaces           | Flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications (no corrugations) |
| Application temperature range  | 28° to 110°F (-2° to 43°C) (air and surface)   |
| Roll sizes                     | 36" x 45 feet (914 mm x 13.5 m)<br>54" x 45 feet (1372 mm x 13.5 m)  |

## How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at [www.scotchprint.com](http://www.scotchprint.com)

### Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

### Warranted Durability

| Media 8522 with Overlaminate 8519 or 8520 | Epson Printers |         | HP Printers |         |
|---|----------------|---------|-------------|---------|
|   | Outdoor        | Indoor  | Outdoor     | Indoor  |
| Applied to Warranted Substrates           | 2 years        | 5 years | 3 years     | 5 years |

### Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

### Fabrication

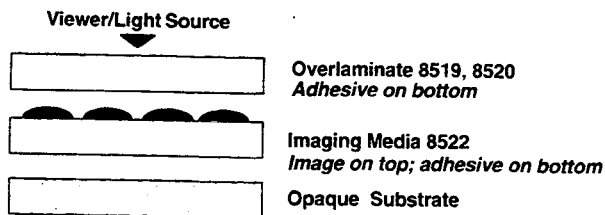
Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

## Graphic Construction Options

### Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.




Note: For the full product names of the 3M products listed on this page, please see page 1.

## Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
  - Original packaging, including plastic wrap
  - Relative humidity of 20% to 80%
  - Temperature of 33° to 104°F (0° to 40°C)
  - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

## Health and Safety

 **Caution**

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

## Warranty and Limited Remedies

### 3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

The following is made in lieu of all other express or implied warranties, including any implied warranty of **merchantability** or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These

### 3M

**Commercial Graphics Division**  
 3M Center, Building 220-6W-06  
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 Technical Info: 1-800-328-3908  
 Fax: 1-651-736-4233

Fax-on-Demand: 1-800-364-0768 (US/Canada) or 1-651-732-6506 International  
[www.scotchprint.com](http://www.scotchprint.com)

**3M Canada**  
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**3M México, S.A. de C.V.**  
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 52-55-52-70-04-00  
 Fax: 52-55-52-70-22-77

**3M Puerto Rico, Inc.**  
 Puerto Rico Industrial Park  
 P.O. Box 100  
 Carolina, PR 00986-0100  
 787-620-3000  
 Fax: 787-750-3035

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

## 3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at [www.scotchprint.com](http://www.scotchprint.com), or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768  
 International: 1-651-732-6506

| Subject  | Bulletin No. | FOD No. |
|--|--------------|---------|
| <b>Product Bulletins</b>   |              |         |
| 3M™ Scotchcal™ Overlamine 8519 and 8520  | 8519/8520    | 4524    |
| <b>Instruction Bulletins</b>   |              |         |
| Making thermal ink jet graphics  | 4.23         | 6523    |
| Application, substrate selection, preparation and substrate-specific application techniques    | 5.1          | 7001    |
| <b>Warranties</b>  |              |         |
| <b>Worldwide 3M™ MCS™ Warranty Packet</b><br>(includes all Commercial Graphics MCS Warranties) |              | 9503    |
| Worldwide 3M™ MCS™ Warranty Overview-Folder  |              | 9504    |

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## Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000, 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.